

Work Order ID 117741

Thursday, May 01, 2014 10:22:58 AM

117741

Page 1

Item ID: D3140-08

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: CL Date: 14/05/01 Tooling: _____

Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3140	Rev F								

100

0.00

100

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

14/07/24 CL

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS

06

9-89

OCT 22 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
--	--	---	---

Work Order ID 117741

Thursday, May 01, 2014 10:22:58 AM

117741

Page 2

Item ID: D3140-08

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Purchasing

Memo

0.00

Purchasing

Issue P/O: 24037

Purchase Part Number: D3140-08

Supplier: Delastek

Ship kit and make as per dwg

Conformity Certificate and Process sheet required

CL 14/07/24

130

Receive & Inspect for Damage & Mat'l Certs

0.00

130

Packaging

Memo

0.00

Packaging

IX SP14-10-20

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

Quality Control

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

DAS

16

9-89

14/10/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Work Order ID 117741

Thursday, May 01, 2014 10:22:58 AM

117741

Page 3

Item ID: D3140-08

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Door

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: CA

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14-10-2214/10/23

JMF

14-10-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

Thursday, May 01, 2014 10:22:57 AM

Page 1

Work Order ID: 117741

117741

Parent Item: D3140-08

D3140-08

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 12/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3140-10		Manufactured	No			100	Each	4.0000	1	1			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3140-10

Doubler Assembly

CX 14/06/17

Location

Loc Qty

Loc Code

ST156

4

53768

4

D3140-92		Manufactured	No			100	Each	10.0000	1	1			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3140-92

Doubler

CX 14/06/17

Location

Loc Qty

Loc Code

CA

10

34374

1

50384

9

D3140-99		Manufactured	No			100	Each	3.0000	1	1			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3140-99

Doubler

CX 14/07/24

Location

Loc Qty

Loc Code

CA

3

36761

1

52632

2

D3140-101		Manufactured	No			100	Each	3.0000	2	2			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3140-101

Doubler

CX 14/07/24

Location

Loc Qty

Loc Code

ST027

3

78724

3

B 118968 x2.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

Thursday, May 01, 2014 10:22:57 AM

Page 2

Work Order ID: 117741

117741

Parent Item: D3140-08

D3140-08

Parent Item Name: Door

Start Date: 5/1/2014

Required Date: 12/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3140-104

Manufactured No

100

Each

2.0000

1

1

D3140-104

Doubler

CL14/06/17

Location

Loc Qty

Loc Code

CA

2

34378

2

1X B118980

D3140-106

Manufactured No

100

Each

2.0000

1

1

D3140-106

Doubler

CL14/06/17

Location

Loc Qty

Loc Code

CA

2

34380

2

1

D3140-303

Manufactured No

100

Each

2.0000

1

1

D3140-303

Doubler

CL14/07/24

Location

Loc Qty

Loc Code

ST241A

2

84215

2

B118890

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
--	--	---	---



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24037**

Purchase Order Date 5/1/2014

PO Print Date 9/10/2014

Page Number 3 of 6

Order From :

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Michael Gregoire

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

EXW - (Ex Works)

✓ 6	D3140-06P	Door	9/10/2014	1.00	\$8,842.92	\$8,842.9
			Yes	Each		
			9/10/2014			

Manufacture as per Drawing D3140 rev.F

Line Total: \$8,842.9

✓ 7	D3140-07P	Door	9/10/2014	1.00	\$8,842.92	\$8,842.9
			Yes	Each		
			9/10/2014			

Manufacture as per Drawing D3140 rev.F

Line Total: \$8,842.9

⑧	D3140-08P	Door	9/10/2014	1.00	\$8,842.92	\$8,842.9
			Yes	Each		
			9/10/2014			

Manufacture as per Drawing D3140 rev.F

Line Total: \$8,842.9

SPH 10-20

PO Instructions: Fedex Acc# 151793240

Note:

9/10/2014

Mastering Innovation

DELASTEK

DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP**CERTIFICATE OF COMPLIANCE**

Invoice No.	58543
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
16-10-2014	01-05-2014	24599	Michael Gregoire	PO24037 REV 1	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Freight LTL Collect	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship	Item number	Description	
1	0	1	DKC135-0017	Line #5 D3140-05 Door Left Non Assy (Grosse) U of M: Chaq DWG D3140 REV. F Serial # Lot # 62922 62922	
1	0	1	DKC135-0019	Line #6 D3140-06 Door Right Non Assy (Grosse) U of M: Chaq DWG D3140 REV. F Serial # Lot # 62923 62923	
1	0	1	DKC135-0018	Line #7 D3140-07 Door Left Non Assy (Petite) U of M: Chaq DWG D3140 REV. F Serial # Lot # 62922 62922	
1	0	1	DKC135-0020	Line #8 D3140-08 Door Right Non Assy (Petite) U of M: Chaq DWG D3140 REV. F Serial # Lot # 62923 62923	

DOCUMENT INCLUS

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-35

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2014-07-01 12:27:41
Utilisateur: marc dubé

Feuille de Procédé

8/18 Août

Client	: DART US DART AEROSPACE	Nom Dessin	: DOOR KIT
Numéro Job	: 62923	Numéro Article	: DKC135-0019/-0020
Numéro	: 3407	Numéro Dessin	: D3140
Numéro B.A.	:	Projet Numéro	: DK-359
Cette fois	: 2014-07-01 No. :	Révision dessin	: F
Prsht Rev.	: NC	Matériel	: Fibercote E-761
Prem. fois	: - - Type :	Date Dûe	: 2014-09-15
Job précédente	: 61668	Qté:	1 Ud UNITE
Écrit par	:		2014-10-13
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D3140-06/-08		



Process Sheet Rév.: 05 remplacer AAC0559 et AAC0563 par AAC2032 et AAC1361 respectivement, changé AC0883 et AC0884 par AAC1885 et AAC1887 respectivement à 2 endroits qui avait été oubliés

COPIE

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC0854 Frekote #700-NC

Comment Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)
Frekote #700-NC N° de Lot: 1-45935-1

2.0 PRÉPARATION Préparation du moule



Comment Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

Faire la préparation du moule selon IF135-0002 et IG 0009.

Date: 4/09/14 Sceau:



3.0 AMB0211 Epoxy prepreg E-761 style 7781

Comment Qty.: 12.30 VERGE(s)/Unit Total: 12.30 VERGE(s)
Epoxy prepreg E-761 style 7781 N° de Lot: 4575720AA

4.0 DECOUPE Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Découpe des tissus pré-impregné E-761 en paquet de 10.5 (7 Paquet = 24.5 verges)















Quantité: 1 Date: 4.9.14 Sceau:



Date: Mardi, 2014-07-01 12:27:41

Utilisateur: marc dubé














Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: DOOR KIT	
Numéro Job: 62923	Numéro DKC135-0019/0020	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
5.0	DRAPAGE	Drapage
 		
Comment Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs		
Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0002		
Quantité: <u>1</u> Date: <u>05-09-14</u> Sceau:  		
6.0	AAC1885 AAC 1952	Tissu à délaminer Release ply B
Comment Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)		
Tissu à délaminer Release ply B # de Lot: <u>1-42026-2</u>		
7.0	AAC1887	Wrighton 5200 Bleu P3
Comment Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)		
Wrighton 5200 Bleu P3 # de Lot: <u>1-45581-1</u>		
8.0	AC0885	Feutre de drainage N° Airweave N 10
Comment Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)		
9.0	AC0882	Sac à vide N° Strechlon 700
Comment Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)		
10.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
Comment Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)		
11.0	BAGGING	Faire le bagging sur la pièce
 		
Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs		
Faire le bagging sur la pièce selon IF135-0002 et IG 0012		
Quantité: <u>1</u> Date: <u>8-09-14</u> Sceau:  		
12.0	CUISSON	Cuisson de pièce
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs		
Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N°		
Cuisson: <u>8778</u>		
Quantité: <u>1</u> Date: <u>9-09-14</u> Sceau: 		
13.0	DÉMOULAGE	Démoulage de la pièce
 		
Comment Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs		
Retirer le montage cuisson et faire les retouches de la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.		

Date: Mardi, 2014-07-01 12:27:41

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: DOOR KIT	
Numéro Job: 62923		Numéro DKC135-0019/-0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Quantité: 1	Date: 12/09/14	Sceau:  	
14.0	INSPECTION	Inspection générale	
			
Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.			
Quantité: 1	Date: 12/09/14	Sceau: 	
15.0	AAC1618	Rohacell 71S 1"thick 49.2" x 98.4" plain	
Comment Qty.: 2.000 FEUILLE(s)/Unit Total: 2.000 FEUILLE(s) Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: 1-45735-1			
16.0	DECOUPE	Découpe manuelle des pièces	
			
Comment Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs			
Faire la découpe des pièces de mousses structurales (Rohacell) sur la scie à ruban selon IF135-0002.			
Quantité: 1	Date: 15/09/14	Sceau:  	
17.0	SÉCHAGE/ ANEAL	Séchage / Annealing	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le séchage du Rohacell selon IF135-0002 et les informations du manufacturier. N° Cuisson: 8796			
Quantité: 1	Date: 12/09/14	Sceau: 	
18.0	AMB0442	Film adhesif EA9696 36" large x 0.06(psf)	
Comment Qty.: 6.12 VERGE CAR(s)/Unit Total: 6.12 VERGE CAR(s) Film adhesif de EA9696 36" large x 0.06 (psf) N° de Lot: 64184 4723610 AA			
19.0	AAC2032	Core splice adhesive NB-51/301	
Comment Qty.: 5.0 PIED CARRE(s)/Unit Total: 5.0 PIED CARRE(s) Core splice adhesive NB-51/301 # de Lot: 1-45752-1			
20.0	AAC1361	Putty AD Tech P-17	
Comment Qty.: 0.50 UNITE(s)/Unit Total: 0.50 UNITE(s) Putty AD Tech P-17 # de Lot: 1-45756-1			

Date: Mardi, 2014-07-01 12:27:41

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 62923

Numéro DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

21.0 AAC1646 N° D3140-10, Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-10, Doubler N° de Lot: 47437140AA

22.0 AAC1631 N° D3140-87, Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-87, Doubler N° de Lot: 4743710AA

23.0 AAC1633 N° D3140-92, Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-92, Doubler N° de Lot: 47437150AA

24.0 AAC1634 N° D3140-95, Doubler

Comment Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)
N° D3140-95, Doubler N° de Lot: 4743720AA

25.0 AAC1636 N° D3140-98, Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-98, Doubler N° de Lot: 4743760AA

26.0 AAC1637 N° D3140-99, Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-99, Doubler N° de Lot: 47437100AA

27.0 AAC1638 N° D3140-101, Doubler

Comment Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)
N° D3140-101, Doubler N° de Lot: 47437110AA

28.0 AAC1640 N° D3140-104, Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-104, Doubler N° de Lot: 47437160AA

29.0 AAC1642 N° D3140-106, Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-106, Doubler N° de Lot: 47437170AA

30.0 AAC1643 N° D3140-241, Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
N° D3140-241, Doubler N° de Lot: 4743740AA

31.0 AAC1645 N° D3140-303, Doubler

Comment Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)
N° D3140-303, Doubler N° de Lot: 4743770AA

32.0 NETTOYAGE Nettoyage des pièces



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs











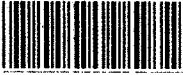


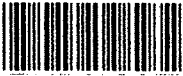

Faire le nettoyage des doublers selon IG 0063.

Quantité: 1 Date: 15-09-14 Sceau:



Date: Mardi, 2014-07-01 12:27:41
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	DOOR KIT
Numéro Job:	62923	Numéro	DKC135-0019/-0020
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
33.0	ASSEMBLAGE	Assemblage mécanique	
 			
Comment Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Mise en place des doublers et des pièces de la mousse structurale selon IF135-0002.			
Quantité: <u>1</u> Date: <u>17-09-14</u> Sceau:  			
34.0	AAC1885	Tissu à délaminer Release ply B	
Comment Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)			
35.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)			
36.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)			
37.0	AC0882	Sac à vide N° Strechlon 700	
Comment Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)			
38.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)			
39.0	BAGGING	Faire le bagging sur la pièce	
 			
Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs			
Faire le montage cuisson selon IF135-0002 et IG 0012.			
Quantité: <u>1</u> Date: <u>17-09-14</u> Sceau:   			
40.0	CUISSON	Cuisson de pièce	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #21. N°			
Cuisson: <u>8808</u>			
Quantité: <u>1</u> Date: <u>17-09-14</u> Sceau: 			
41.0	DÉMOULAGE	Démoulage de la pièce	
 			
Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs			
Retirer le montage cuisson de sur la pièce et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium. Garder seulement la barre qui sépare les deux pièces.			
Quantité: <u>1</u> Date: <u>18-09-14</u> Sceau: <u>4475 R.S.</u>			

Date: Mardi, 2014-07-01 12:27:41
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 62923

Norm Dessin: DOOR KIT
Numéro DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

42.0

DECOUPE

Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Usinage des mousses structurales selon IF135-0002 et installer les doublers

Quantité: 1

Date: 24/09/14

Sceau:



43.0

INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

Quantité: 1

Date: 24/09/14

Sceau:



44.0

AMB0211

Epoxy prepreg E-761 style 7781

Comment Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)

Epoxy prepreg E-761 style 7781

N° de Lot: 4575720AA

45.0

DRAPAGE

Drapage



Comment Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Drapage de la coquille intérieure selon IF135-0002

Quantité: 1

Date: 26-09-14

Sceau:



46.0

AAC1885

Tissu à délaminer Release ply B

Comment Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

47.0

AAC1887

Wrightlon 5200 Bleu P3

Comment Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

48.0

AC0885

Feutre de drainage N° Airweave N 10

Comment Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

49.0

AC0882

Sac à vide N° Strechlon 700

Comment Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

50.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

Date: Mardi, 2014-07-01 12:27:41

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 62923

Numéro DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

51.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012.

Quantité: 1

Date: 26-09-14

Sceau:



52.0

CUISSON

Cuisson de pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N°

Cuisson: 8834

Quantité: 1

Date: 29-09-14

Sceau:



53.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.

Retirer la pièce du moule.

Quantité: 1

Date: 2/10/14

Sceau:



54.0

INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnelle".

Quantité: 1

Date: 03/10/14

Sceau:



55.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003.

Quantité: 1

Date: 3/10/14

Sceau:



Date: Mardi, 2014-07-01 12:27:41

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: DOOR KIT

Numéro Job: 62923

Numéro DKC135-0019/-0020

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

56.0	AAC1021	Dupont Primer N° 7704S
------	---------	------------------------

Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-54556-3

57.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
------	---------	---

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 4768410A1

58.0	PRIMER	Application primer
------	--------	--------------------



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 06-10-14 Sceau: 22349 N° fiche
Mélange: 10524

59.0	SABLAGE	Sablage
------	---------	---------



Comment Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Faire le sablage du primer selon IF135-0003.

Quantité: 1 Date: 9/10/14 Sceau: 56 N° fiche



60.0	PRIMER	Application primer
------	--------	--------------------



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 13-10-14 Sceau: 76 N° fiche
Mélange: 10521

61.0	IDENTIFICATION	Identification des pièces
------	----------------	---------------------------



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanismes de porte selon IG 0055.

N° de pièce Grosse porte: D3140-06

N° de pièce Petite porte: D3140-08







N° de Job (sur les 2 pièces): 62923

Date de fabrication (sur les 2 pièces): 14-10-14

Sceau d'inspection.


Date: Mardi, 2014-07-01 12:27:41
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	DOOR KIT
Numéro Job:	62923	Numéro	DKC135-0019/-0020
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Quantité: <u>1</u> Date: <u>14-10-14</u> Sceau: <u>4451</u>			
62.0	INSPEC FINAL	Inspection finale	
			
Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.			
Quantité: <u>1</u> Date: <u>16-10-14</u> Sceau: 			
63.0	EMBAL / ENTREPO	Emballage & Entreposage	
			
Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
Emballer et entreposer selon IG 0057.			
Quantité: <u>1</u> Date: <u>16-10-14</u> Sceau: <u>4451 8m</u>			

N° Bon de travail: 62923.

N° pièce: D/C C 135-00196020

Article	Description	N° lot	Date de sortie	Heure de sortie	Temps restant Temp. Ambiante	Date expiration	Sceau employé
AAC1471	COPPER MESH						
AAC1541	CORE SPLICE						
AMB0211	EPOXY PREPREG	4575720AA	3-9-14	16h ⁰⁰	720hrs	26-12-14	
AMB0327	EPOXY PREPREG						
AMB0326	CARBONE						
AMB0442	FILM ADHÉSIF						